

Date: Wednesday, 9/26/2007 2:06:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 34883	
Estimate Number : 12731	
P.O. Number : <i>N/A</i>	Part Number : D353535
This Issue : 9/26/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33371	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/10/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>50</i> Um: Each
Comment : Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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*42.115 sf*

Comment: Qty.: 0.8423 sf(s)/Unit Total : 25.2693 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *105841* *IB 07-10-10*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *B* *IB 07-10-10*Prog Rev: *B**(52)*2-Deburr if necessary *IB 07-10-10*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*IB 07-10-10*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IB 07/10/11 *(52) counter*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

3-Identify as D3535-35.

IB 07/10/11 *(52)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/18/15

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:06:47 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 34883

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
07/10/11 (52)

7.0

POWDER COATING

POWDER COATING



M 104846



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 07/10/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ml 07/10/13



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(52)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: F.P

ml 07/10/13

(52)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/15 (52)

Job Completion



07/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 34883
Description: Wearshoe		Part Number: D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	*			
1.885	+/-0.010	1.885	*			
6.00	+/-0.030	6.00	*			
6.75	+/-0.030	6.75	*			
Ø0.188	+0.005/-0.001	.189	*			
23.250	+/-0.010	23.250	*			
19.750	+/-0.010	19.750	*			
17.750	+/-0.010	17.750	*			
14.250	+/-0.010	14.250	*			
9.500	+/-0.010	9.500	*			
4.750	+/-0.010	4.750	*			
0.300	+/-0.010	.304	*			
0.300	+/-0.010	.304	*			
0.038	+/-0.010	.034	*			

Measured by: B	Audited by: E	Prototype Approval:	N/A
Date: 07-10-10	Date: 07/10/11	Date:	N/A

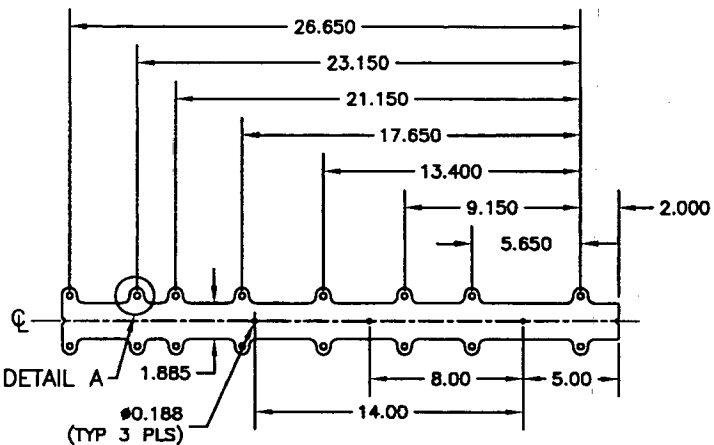
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

DART

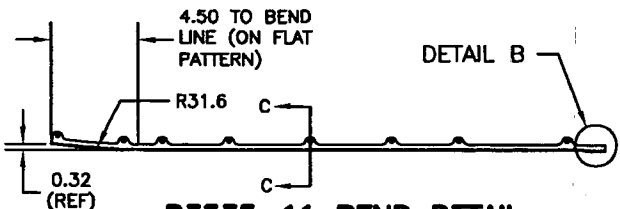
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07.04.24

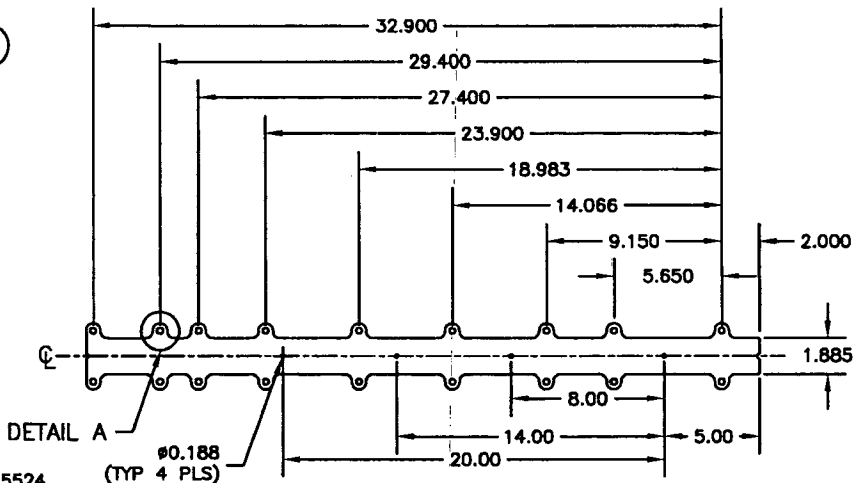
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	WEARSHOE	REV. B
				SHEET 1 OF 7
				SCALE
				1:10
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		



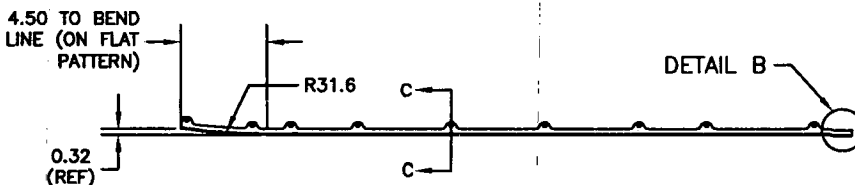
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

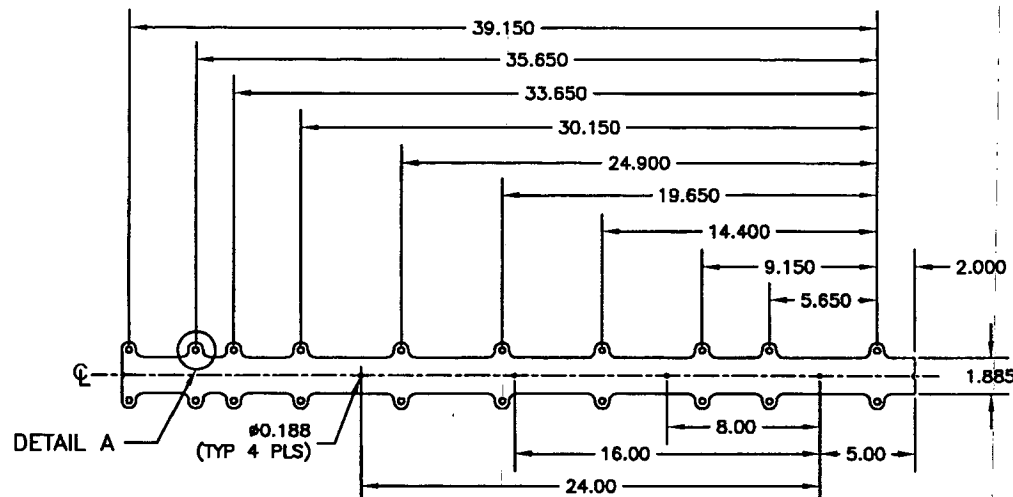
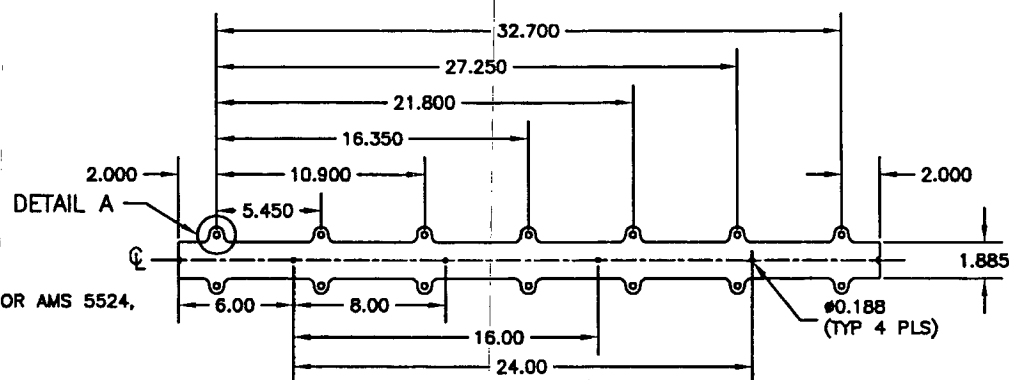
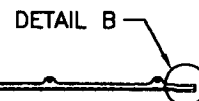
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WORK ORDER
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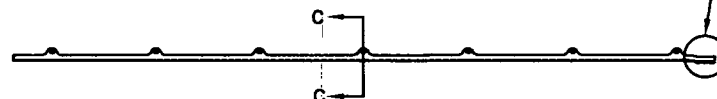
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		D3535	SHEET 2 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

4.50 TO BEND
LINE (ON FLAT
PATTERN)**D3535-15F FLAT PATTERN**0.32
(REF)**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN**

DETAIL B

**D3535-21 BEND DETAIL****NOTES**

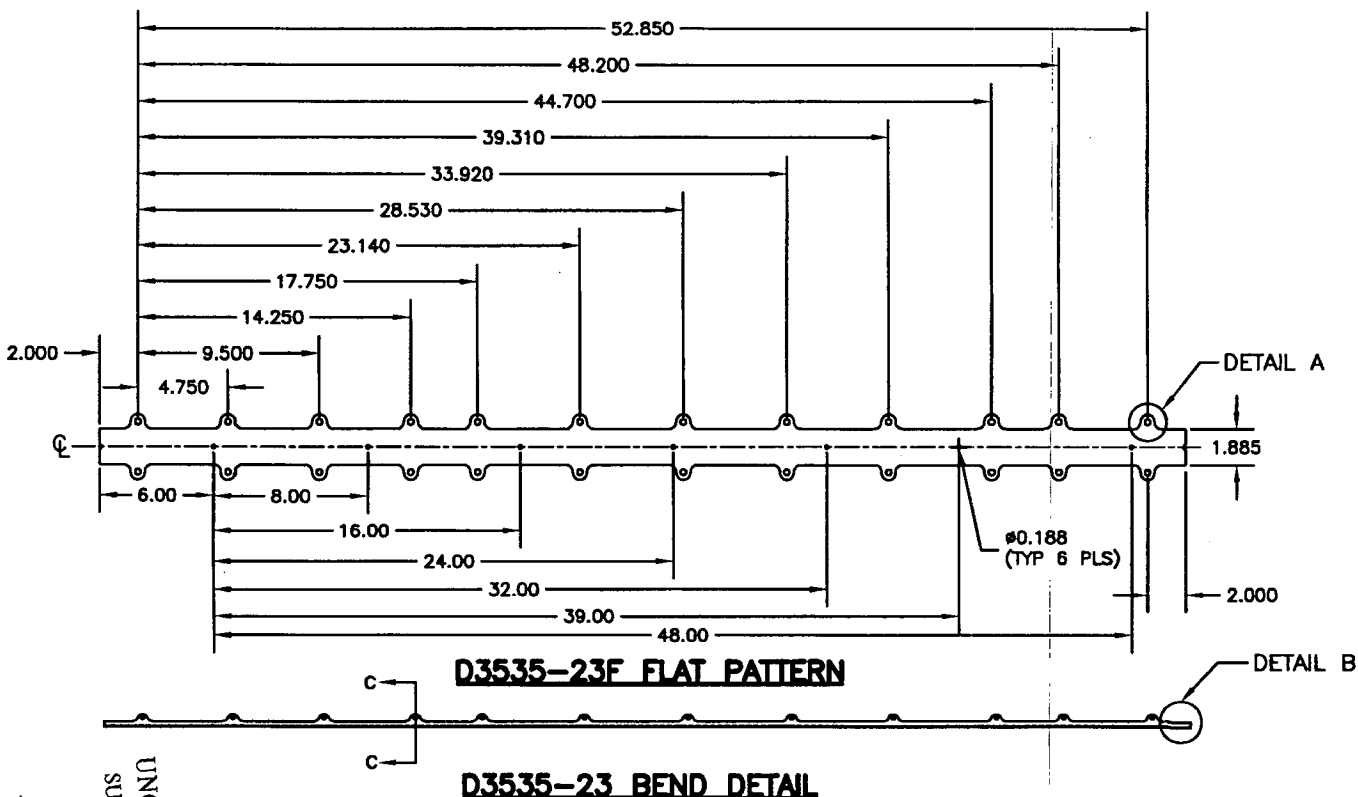
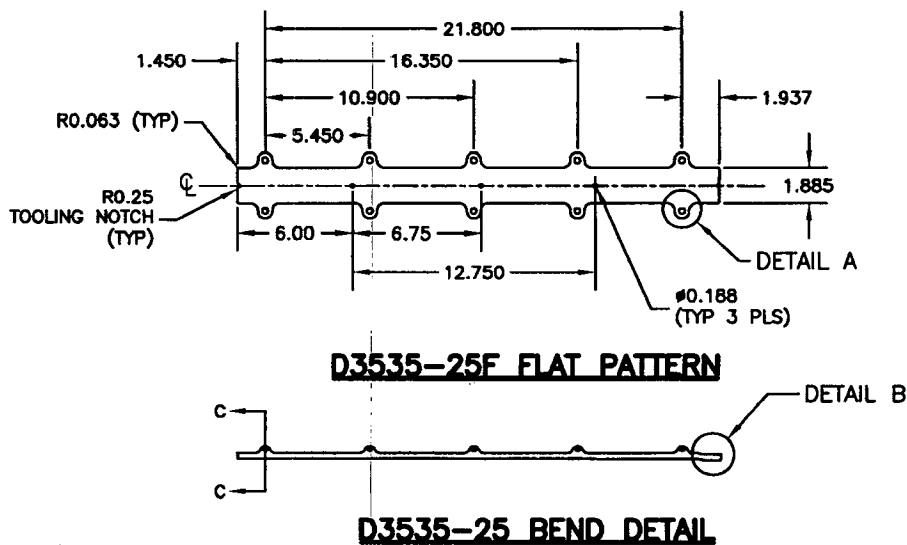
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- 3) PART IS SYMMETRICAL ABOUT ϕ
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL**

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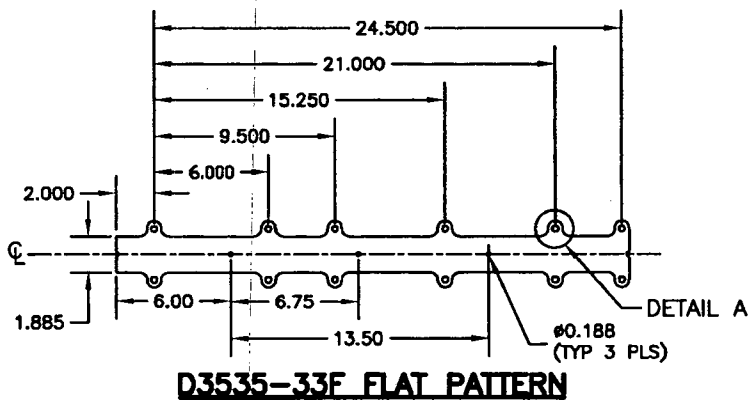
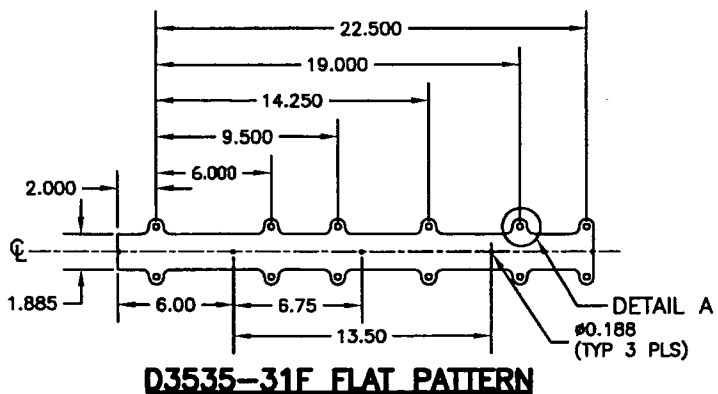
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CB	PH	PORT HADLOCK, WA
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DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE 1:10

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DATE	TITLE	WEARSHOE	SCALE	
07.04.17			1:10	



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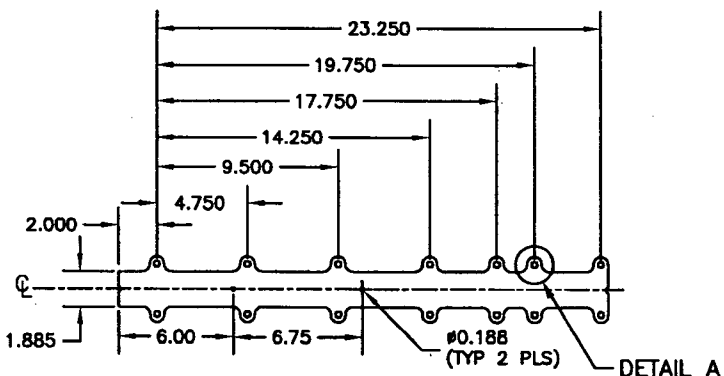
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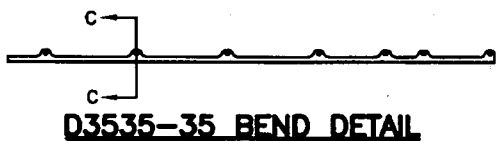
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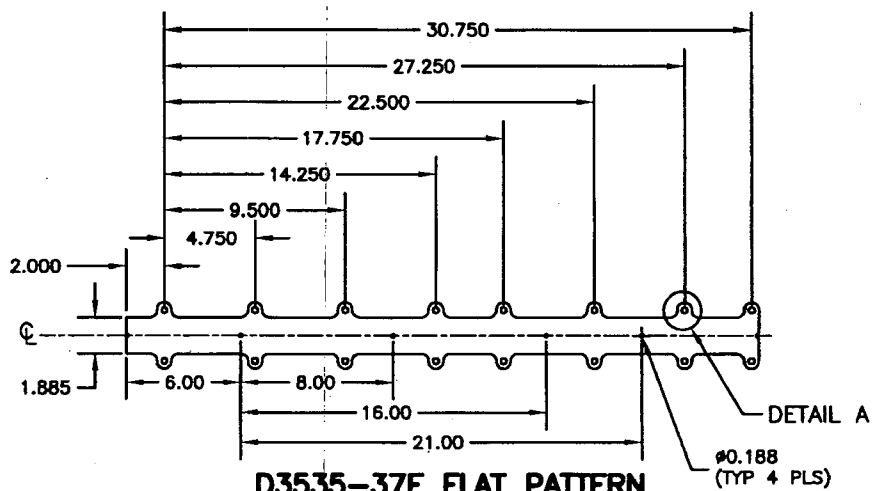
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NOTES

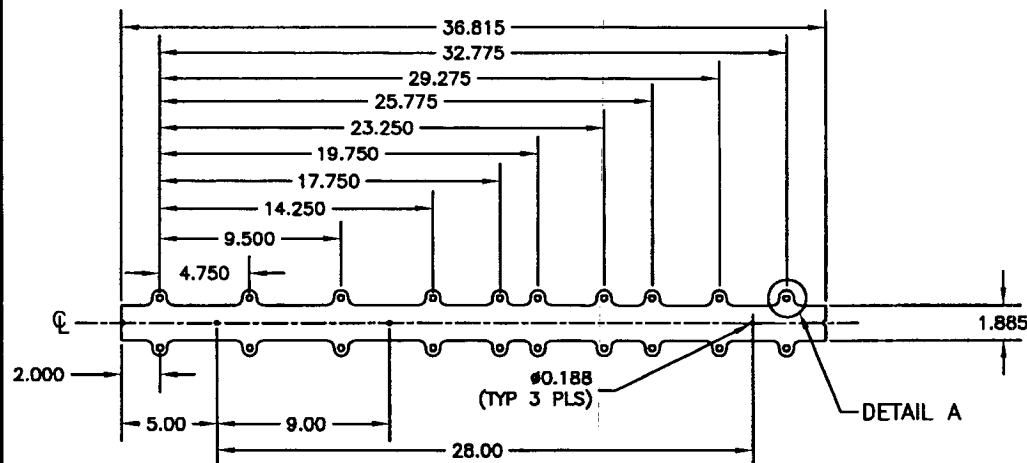
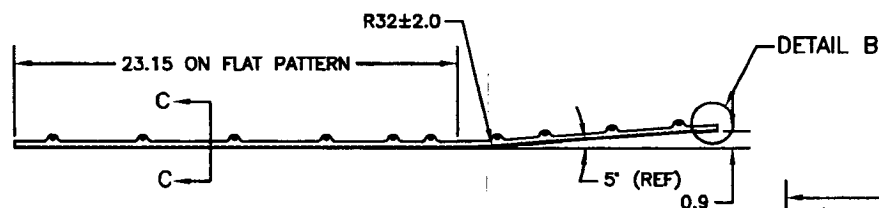
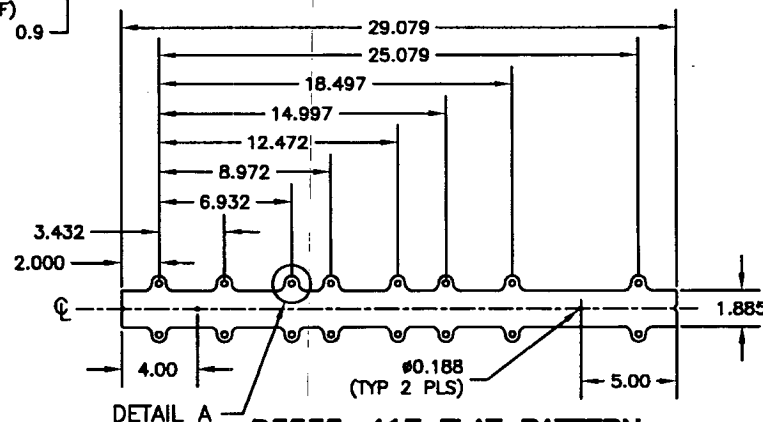
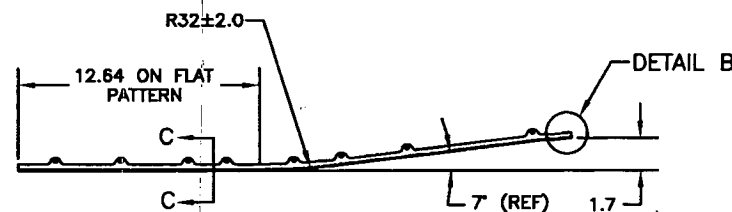
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<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 6 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

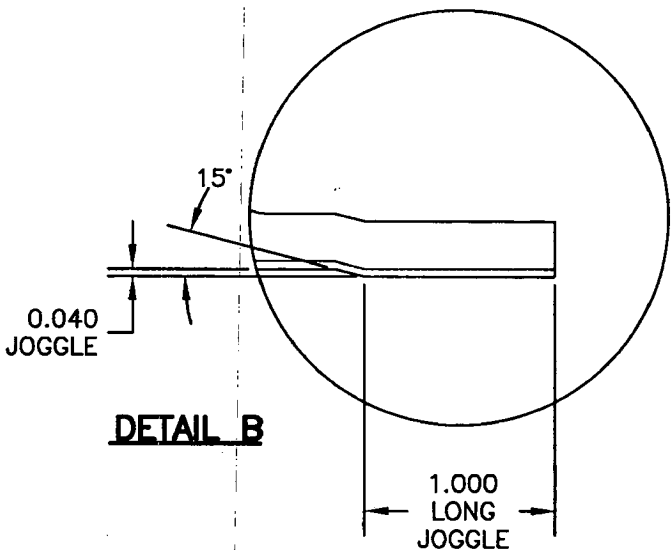
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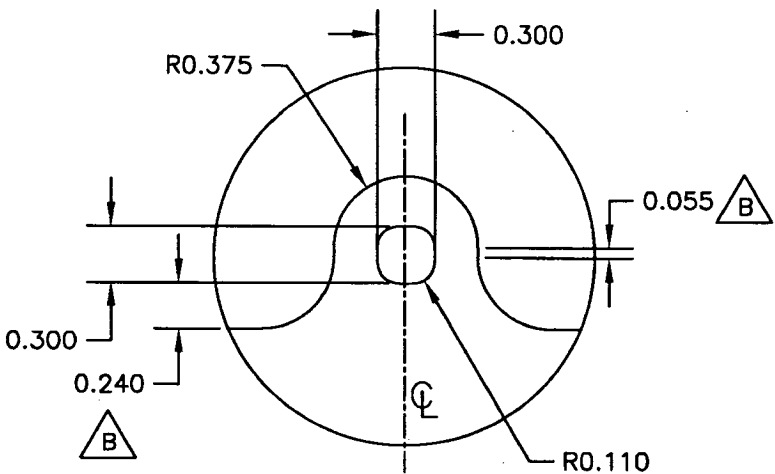


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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
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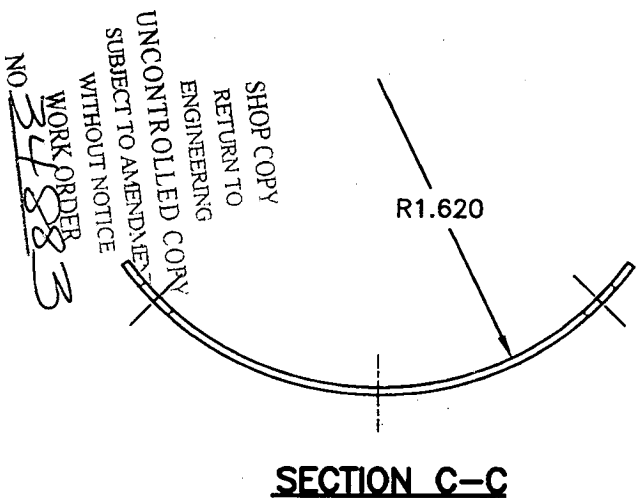
RELEASED
07.04.24 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C